

Date: Thursday, 12/07/2007 10:34:02 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 33244		
Estimate Number	: 12782		
P.O. Number	: <i>NIA</i>	Part Number	: D35643
This Issue	: 12/07/2007 S.O. No. : <i>NIA</i>	Drawing Number	: D3564 UNDER REVIEW
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 28/06/2007 Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 31419	Material	: <i>NIA</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/07/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	20 Um: Each
Comment	: Est Rev:A New Issue 07-03-08 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.9177 sf(s)/Unit Total : 18.3540 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch *M104 725**IB 07-07-16*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3564 ***** (D3564-1F) *****

Dwg Rev: *A*Prog Rev: *A*

2-Deburr if necessary

IB 07-07-16

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

counter
En 07/07/16 *(20)*

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3564 using Jigs DT179 and DT

Form Joggle as per Dwg D3564 on brake using Jig DT8157

*SAD 07/07/16**SB 07/07/18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/07/2007 10:34:02 AM
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Drawing Name: WEARPAD

Job Number: 33244

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Ensure joggle as per dwg D3429

En 07/07/18

(420)

carbo

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty	Description	Batch
A/R	2059B Hardcoat	M105258
Weld hardcoat as per Dwg D3437		

07/07/30

(20x)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/07/30

(20)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/07/30

(20)

10.0

POWDER COATING

POWDER COATING



M104846



(20x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M-L 07/08/03

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(Have to redo one)



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

07/08/07

(20)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-14

M-L 07/08/07

(20x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 01/08/00
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: WEARPAD

Job Number: 33244

Part Number: D35643

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



20

Comment: FINAL INSPECTION/W/O RELEASE

12/07/08/08

Job Completion



12-07-08-06

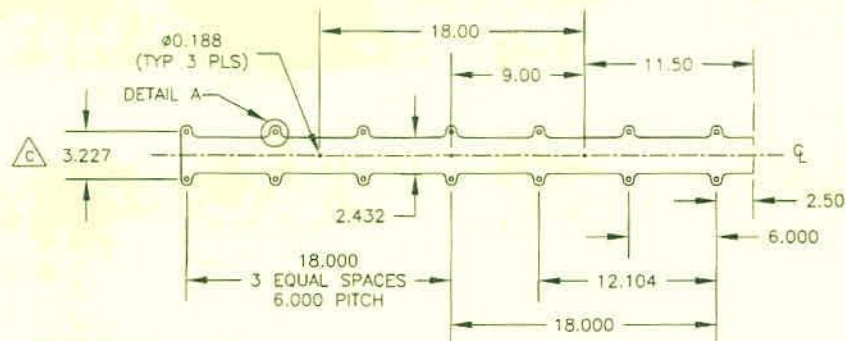
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

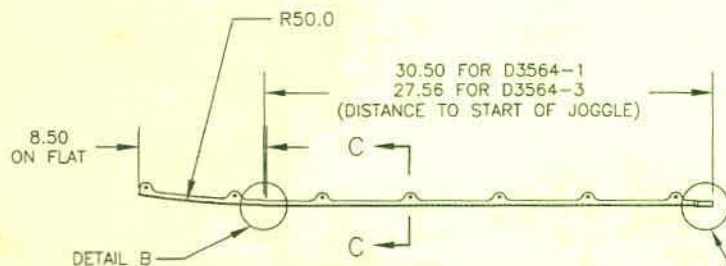
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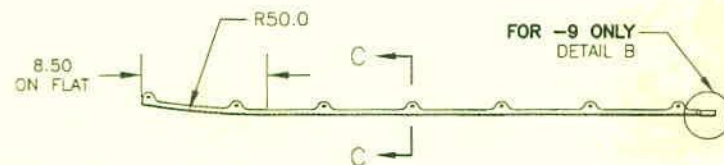
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN

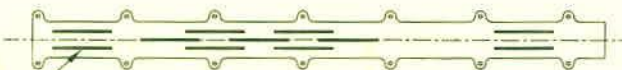


D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D3564-1/-3/-9/-11 WELDING DETAIL

D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

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C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN P.H.	DRAWN BY P.H.	DART DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D3564
DATE 07.04.17	TITLE WEARSHOE	REV. C SHEET 1 OF 2 SCALE 1:8

RELEASED
07.06.28

W/O 32738

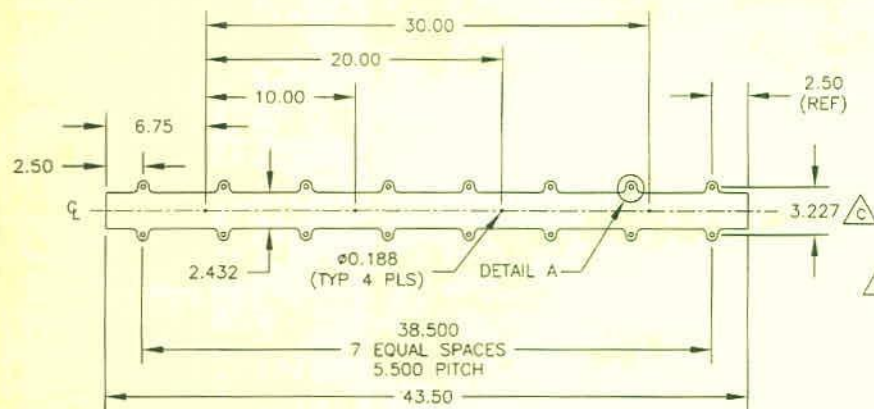
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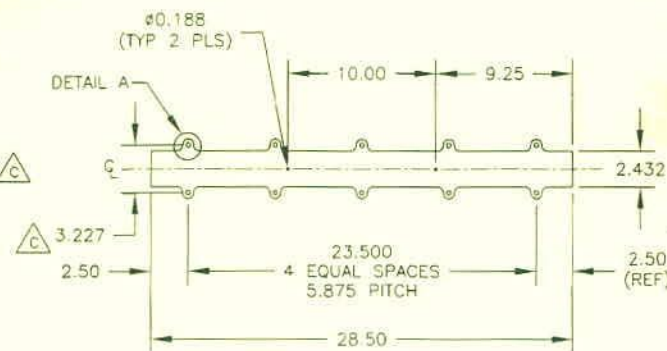
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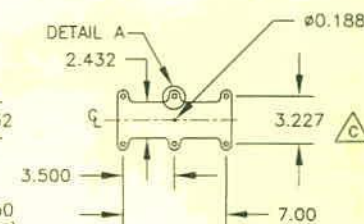
NOTE: Date & initial all entries



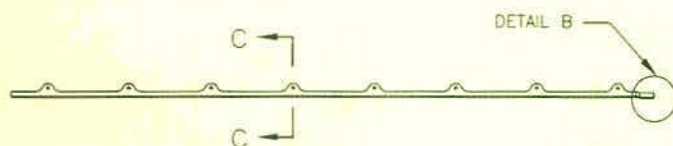
D3564-5F FLAT PATTERN



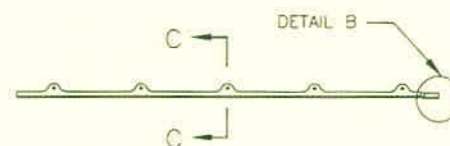
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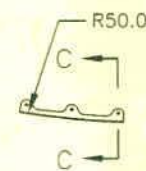
D3564-13F FLAT PATTERN



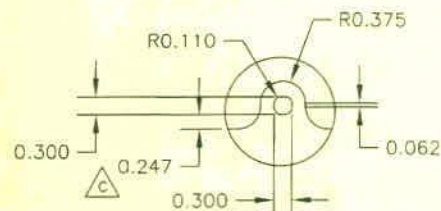
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



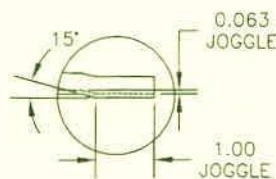
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



DETAIL A
SCALE 1:2



DETAIL B
SCALE 1:2



SECTION C-C
SCALE 1:2

RELEASED
07.06.28

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DESIGN

DRAWN BY

CHECKED

APPROVED

DATE

TITLE

07.04.17

WEARSHOE

DART

DART AEROSPACE LTD.

HAMILTON, ONTARIO, CANADA

DRAWING NO.

D3564

REV. C

SHEET 2 OF 2

SCALE

1:2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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